

**Work Order ID 59186**

Thursday, May 27, 2010 1:19:41 PM



Page 1

Item ID: D3907-1

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 5/27/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-5-27 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberReject  
NumberInsp.  
Stamp

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3907    | A            |

100



Hardinge

Hardinge CNC Lathe Small

Memo

0.00

40 ✓

Machine as per Folio FA823  
& Dwg D3907Dwg Rev:  
folio Rev:  
Deburr

→ 10/06/20

110



QC

Quality Control!

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

40 ✓

→ 10/06/20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 59186**

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

05/10/2021

40 0

130



Packaging

Packaging

Identify as per dwg &amp; Stock Location:

0.00

Basket call

05/10/2021 40x

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/2021 JF

ME

10-6-21

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Picklist Print**

Thursday, May 27, 2010 1:19:45 PM

Page 1

Work Order ID: 59186



Parent Item: D3907-1



Parent Item Name: Bushing

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments:

Start Qty: 40.00

Required Qty: 40.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304R0.375                      |                        | Purchased     |             | No                  |                  | 100             | f                  | 35.2400        | 0.03        | 1.2          |               |                |        |

304 ROUND BAR 0.375



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT             | 29.9           |                 |
| 111323          | 0              |                 |
| 114467          | 12.1           |                 |
| 114676          | 17.8           |                 |
| MAT029          | 5.34           |                 |
| 113325          | 3.85           |                 |
| 114356          | 1.49           |                 |

1.30 ft s1 10/02/20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                       |              |             |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD    | Work Order:  | 59186       |
| Description: Bushing  | Part Number: | D3907-1     |
| Inspection Dwg: D3907 | Rev: A       | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article      Prototype

|              |   |             |   |                     |     |
|--------------|---|-------------|---|---------------------|-----|
| Measured by: |  | Audited by: |  | Prototype Approval: | N/A |
| Date:        | 10/06/20  | Date:       | 10/06/21  | Date:               | N/A |

| Rev | Date     | Change    | Revised by | Approved  |
|-----|----------|-----------|------------|---|
| A   | 09.05.20 | New Issue | KJ         |  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

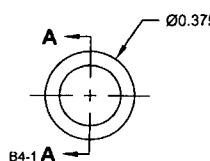
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

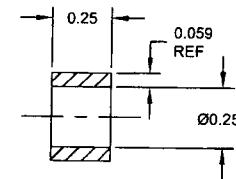
NOTE: Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 59186  
*PS10527*



D3907-1 BUSHING



SECTION A-A C5-1

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD  
REF DART SPEC M304R

OR: AISI 304/316 STAINLESS STEEL BAR  
REF DART SPEC M304B

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

**RELEASED**  
*PS10527*

| A          | NEW ISSUE          | AJS  | 09.03.11     |
|------------|--------------------|--|--------------|
| REV.       | DESCRIPTION        |  | BY DATE      |
| DESIGN     | AJS                | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | AJS                | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | A                  | DRAWING NO.  | REV. A       |
| MFG. APPR. | <i>[Signature]</i> | D3907  | SHEET 1 OF 1 |
| APPROVED   | <i>[Signature]</i> | TITLE  | SCALE        |
| DE APPR.   | <i>[Signature]</i> | BUSHING (BASKET REPAIR)  | NTS          |
| DATE       | 09.03.11           | COPYRIGHT © 2009 BY DART AEROSPACE LTD<br>ALL DOCUMENTS ARE THE PROPERTY OF DART AEROSPACE LTD.<br>NOT TO BE COPIED OR USED FOR ANY PURPOSES EXCEPT AS AUTHORIZED BY DART AEROSPACE LTD.<br>UNAUTHORIZED REPRODUCTION IS PROHIBITED. |              |

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|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries